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D3371-041
Job Sheet 202597



Part No: D3371-041

Job Qty: 2 pcs

Part Name: Tail Rotor Pedal Lock



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/19

Job Tracking No:

Due Date: 12/6/19

Created By: Marie Lajeunesse

Type: Stock *SOLD*

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	2 pcs	12/6/19	12/6/19	0.00	1.06	Small Fab - 1		<i>DAS 58</i> DEC 15 2019 <i>9-00</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
130	Small Fab - 2 - B4B	2 pcs	12/6/19	12/6/19	0.00	1.06	Small Fab - 1 - B4B		<i>DAS 58</i> DEC 15 2019 <i>9-00</i>
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
							Small Fab - 9 - B4B		
140	Small Fab - 3 - B4B	2 pcs	12/6/19	12/6/19	0.00	1.06	Small Fab - 1 - B4B		<i>DAS 58</i> DEC 15 2019 <i>9-00</i>
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
							Small Fab - 9 - B4B		
150	QC 5	2 pcs	12/6/19	12/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		

				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DEC 16 2019
				QC 5 - 61	
				QC 5 - 81	
160 Packaging 3-1 - Stock - B4B 2 pcs	12/6/19	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	2 pcs	12/6/19	0.00 0.00	QC 21 - SA - 21	DEC 16 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	DEC 16 2019
Part Op 120 - ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble Descriptions: hinge.Ensure that assembly opens & closes smoothly. 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest. 3- Fabricate D3371-5 cam as per Dwg D3371. 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply lockite to lock body nut. Qty Part Number Description Batch A/R 262 Lockite 5157330 130 - Assemble lanyard to cyclic sock as per Dwg D3384 MANUFACTURE D2690-24 LAND YARD AS PER DWG					

140 - 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4
150 - (QC5- Inspect part completeness to step on W/O)
160 - (Identify as per dwg & Stock Location:)
170 - (QC21- Final Inspection - Work Order Release)

013454

GA001
GA004
ST498
" ST033
" GA005
GA005
ST500
ST563
GA202

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
238-028	3/16" Dowel Pin .5" long	4 Ea (2 ea)	120-Small Fab - 1	5226094
AN526C832R6	Screw	8 Ea (4 ea)	120-Small Fab - 1	fm131379 5 520891
D2728-7	Dart Logo Label	2 (1 ea)	120-Small Fab - 1	
D3371-1	Pedal Lock Base	2 pcs (1 ea)	120-Small Fab - 1	f148601
D3371-3	Pedal Lock Cover	2 pcs (1 ea)	120-Small Fab - 1	S213020
D3373-7	Cam Lock	2 pcs (1 ea)	120-Small Fab - 1	F80376
D3385-3	Hinge	2 pcs (1 ea)	120-Small Fab - 1	5206332
CBL-1240	Cable	3,3332 ft (1.6666 ea)	130-Small Fab - 2 - B4B	5198626
CBL-460	Loop Sleeve	4 Ea (2 ea)	130-Small Fab - 2 - B4B	5187877
D3384-1	Cyclic Sock	2 pcs (1 ea)	130-Small Fab - 2 - B4B	5209766
HX-81	1/4"-20 SHCS 3/8" long	2 Ea (1 ea)	140-Small Fab - 3 - B4B	5212160
NAS1149F0463P	Washer (AN960-416)	4 Ea (2 ea)	140-Small Fab - 3 - B4B	5212160
				S201001

ST73616

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	238-028	4	111	0
	AN526C832R6	8	204	0
	D2728-7	2	0	0
	D3371-1	2	5	0
	D3371-3	2	4	0
	D3373-7	2	3	0
	D3385-3	2	21	0
	CBL-1240	3	532	0
130-Small Fab - 2 - B4B	CBL-460	4	433	0
	D3384-1	2	8	0
	HX-81	2	35	0
140-Small Fab - 3 - B4B	NAS1149F0463P	4	348	0

Part Specifications

Specifications could not be found.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			